

Monday, 4/23/2007 1:52:52 PM
User: Kim Johnston

Process Sheet

SPLIT-1

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WEARPAD
Job Number	31998 - 1		
Estimate Number	12712		
P.O. Number	N/A	Part Number	D35371
This Issue	4/23/2007 / S.O. No. N/A	Drawing Number	D3537 UNDER REVIEW
Prsht Rev.	NC	Project Number	N/A
First Issue	N/A	Drawing Revision	B PH 07.04.26
Previous Run	31937	Material	N/A
Written By		Due Date	4/30/2007
Checked & Approved By	<u>ML 07.04.26</u>	Qty:	100
Comment	Est Rev:A New Issue 07-02-14 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
		Comment: Qty.: 0.0788 sf(s)/Unit Total : 7.8750 sf(s) M304S16GA .063" 304 SS SHEET Batch: <u>M101873 X</u>
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: <u>B</u> ml 07 04 27 Prog Rev: <u>B</u>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
5.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/05/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
			<u> </u>					

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:52:52 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 31998

Part Number: D35371

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch
A/R 2059B Hardcoat 102755

1-Weld as per Dwg D35371 using Jig DT 8210

2-Remove any weld that penetrated through Wearpadif necessary

FC 07/05/04
40

7.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/05/04
40

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/05/04
40

9.0 POWDER COATING

POWDER COATING



101601

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

07/05/04
40

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



07/05/04
40X

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: FP18

07/05/04
40X

12.0 QC21

FINAL INSPECTION/W/O RELEASE



07/05/04
40

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



07/05/04
40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31998
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537	Rev: A B PH 01-0426	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

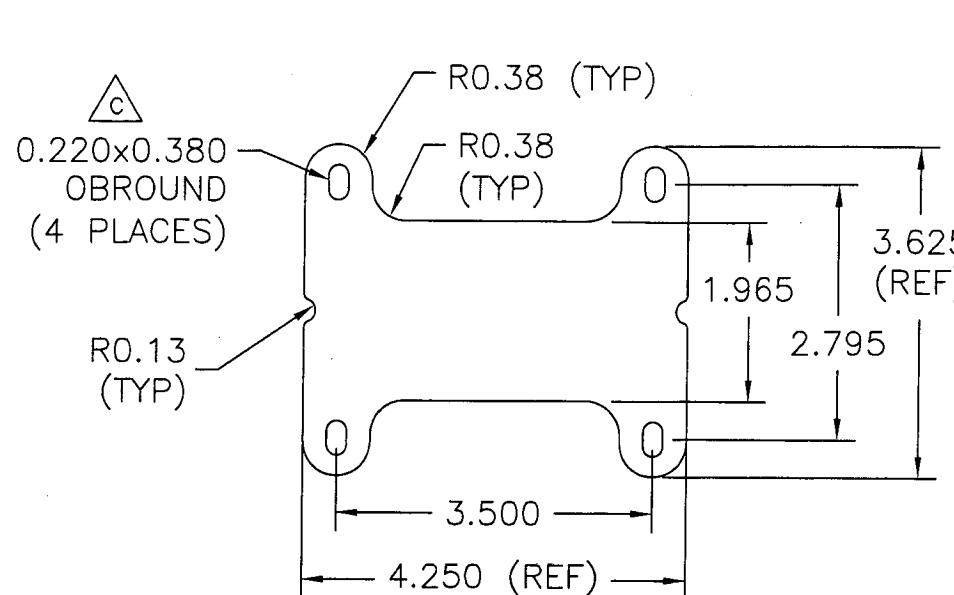
PA
07.04.26

Measured by:	<i>M. M</i>	Audited by:	<i>M</i>	Prototype Approval:	N/A
Date:	07/04/28	Date:	07/04/30	Date:	N/A

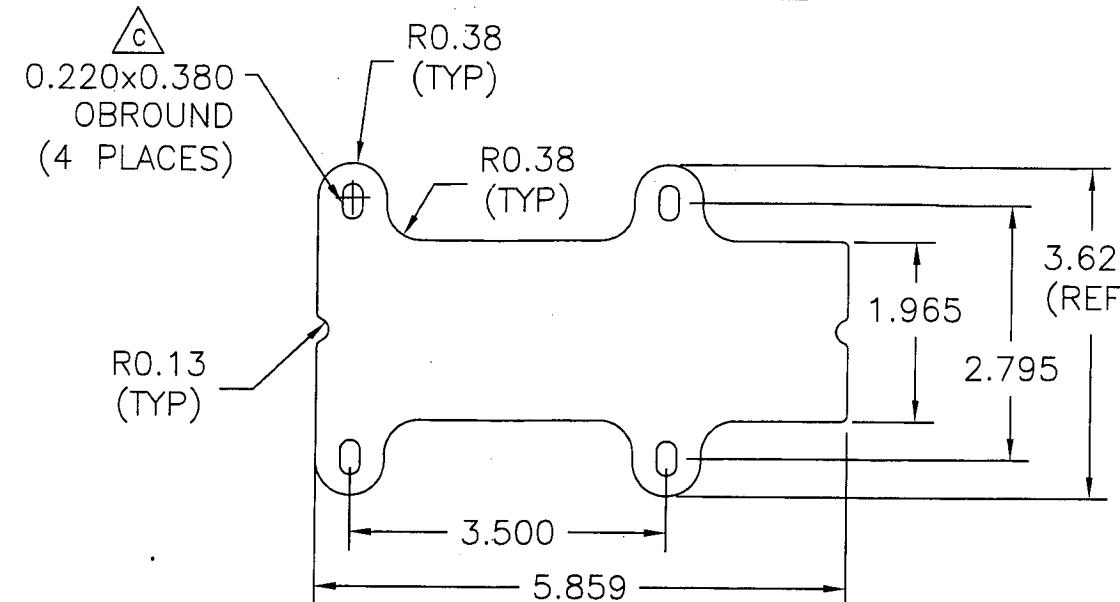
Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM <i>✓</i>	<i>BE</i>



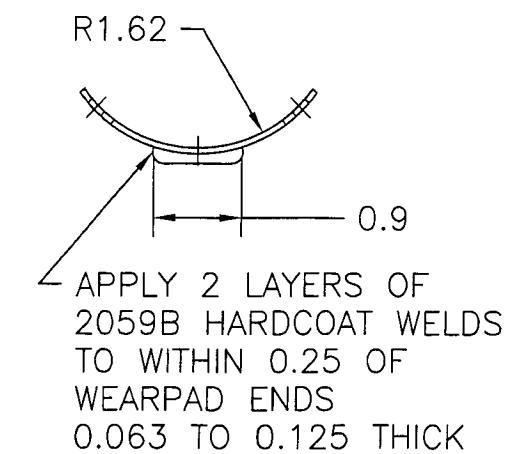
D3537-1F FLAT PATTERN



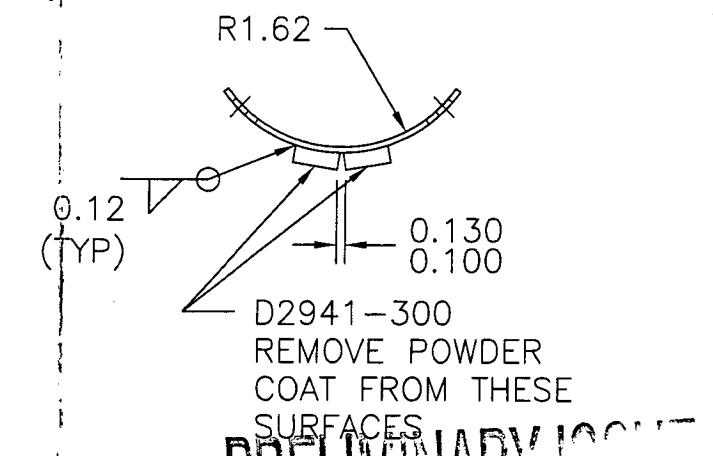
D3537-3F FLAT PATTERN



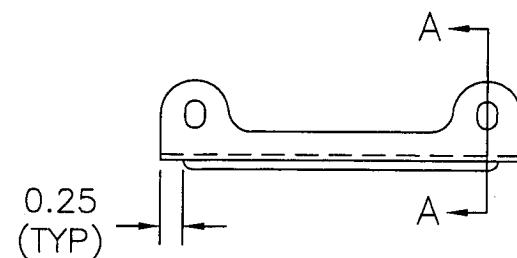
SECTION A-A



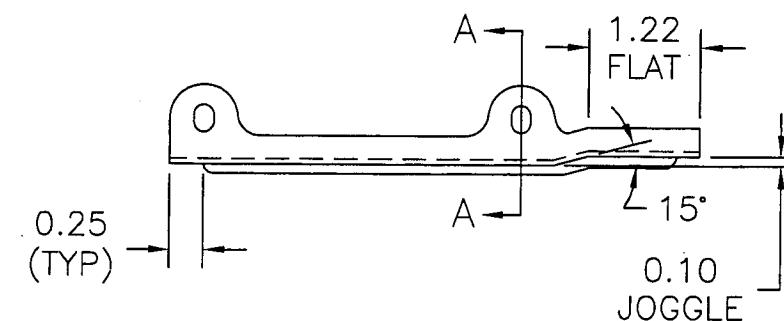
SECTION B-B



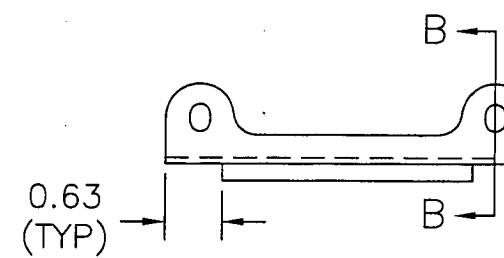
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3537
DATE		REV. C SHEET 1 OF 1 TITLE WEARPAD SCALE 1:2
07.04.13		

